

Work Order ID 149901

August 09, 2016 10:47:51 AM

149901

Page 1

Item ID: D2850-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: End Bracket
 Start Date: 8/8/2016 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 8/15/2016 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: SK Date: AUG 09 2016 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2850	Rev A								
100	BAND SAW	0.00							
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks: 3.8"								
110	HAAS CNC VERTICAL MACHINING #1	0.20							
110									
HAAS 1	Memo	0.73							
HAAS CNC vertical machine #1	Machine per Folio D2850-1 Deburr and Tumble								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.03							
Quality Control									

20 _____ 216815
 20 _____ DAS 33 9-89 16/08/17
 20 _____ DAS 33 9-89 14/08/17

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.07				<u>20</u>	<u>0</u>		DAS 14 9-89 16/08/20
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>wwwp</u> <u>03</u> Memo *** STOCK IN STEP CELL*** LOCATION WA003	0.00 0.03				<u>20x</u>		DAS 43 9-89	AUG 23 2016
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.33						DAS 21 9-89	AUG 24 2016 <u>dem</u> 16/08/23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Picklist Print

August 09, 2016 10:47:56 AM

Page 1

Work Order ID: 149901

149901

Parent Item: D2850-1

D2850-1

Parent Item Name: End Bracket

Start Date: 8/8/2016

Required Date: 8/15/2016

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP B98.12.07Changed folioDM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.500X01.50 0		Purchased	No				f	8.1300		6.315789			

M6061T6B2 500X01 500

6061-T6 Bar 2.50 x 1.50

6.42 2/16/8/5

Location

Loc Qty

Loc Code

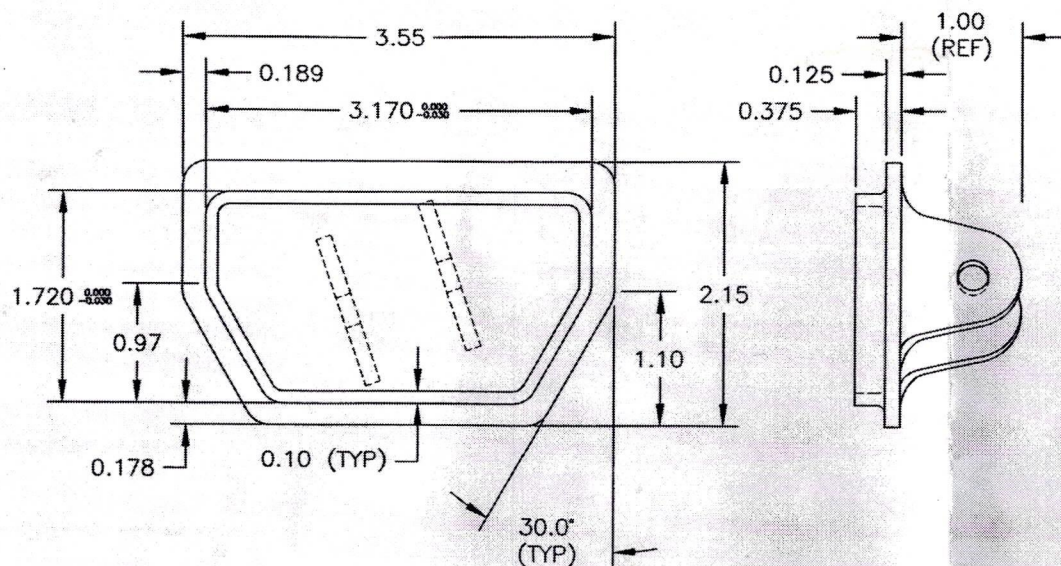
MAT004

8.13

m135169

8.13

6.42



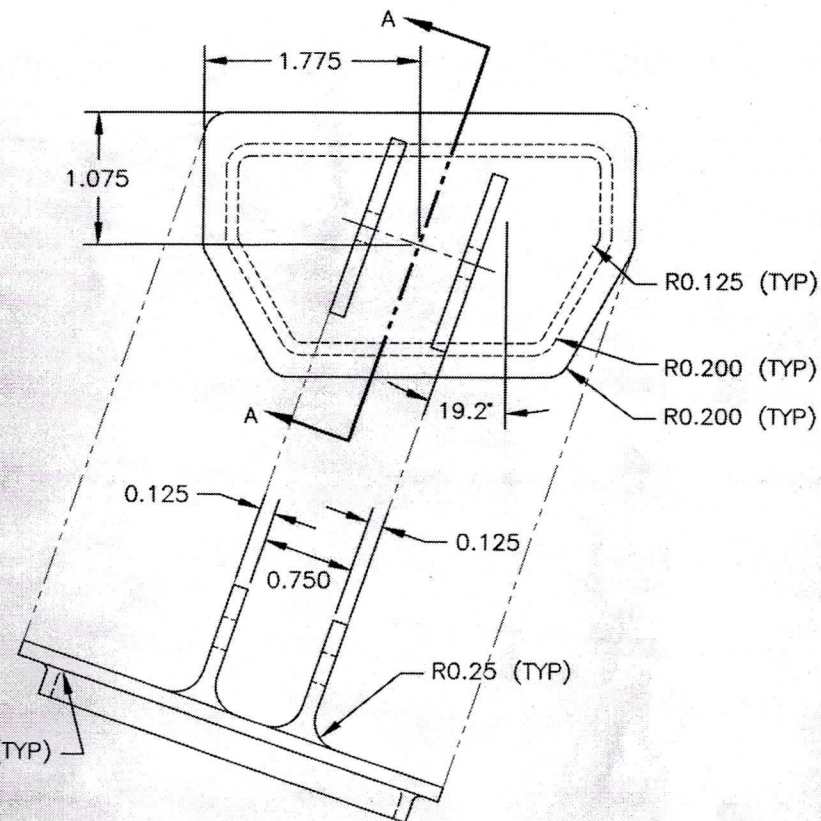
D2850-1 (SHOWN)
D2850-2 (OPPOSITE)

MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)

FINISH: NONE

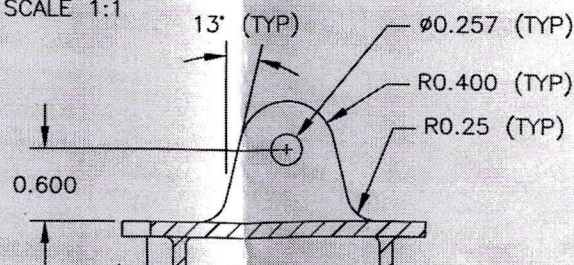
BREAK ALL SHARP EDGES 0.010 TO 0.020

TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED



ISOMETRIC DETAIL
NOT TO SCALE

SECTION A-A
SCALE 1:1



RELEASED
96/125



A	98.11.10	NEW ISSUE, REPLACES D2357 REV. A AND D2358 REV. B
DESIGN	DRAWN BY	DART DART AEROSPACE LTD HARRISBURG, ONTARIO, CANADA
CHECKED KE	APPROVED #	DRAWING NO. D2850
DATE 98.11.10	TITLE HIGH FLOAT STEP END BRACKET	REV. A SHEET 1 OF 1 SCALE 1:1

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 149901

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